

Work Order ID 77551***77551***

Page 1

Item ID: D3890-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Panel, Side

Stop ***NS2***

Start Date: 13/12/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 28/12/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/13 Tooling: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3890

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3890-1

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B12-1-5(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-1-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77551

December-13-11 1:40:51 PM

77551

Page 2

Item ID: D3890-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel, Side
 Start Date: 13/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 28/12/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140		0.00							
140									
Thermoform	Memo	0.00							
Thermoforming Machine	Thermoform using mold DT9489 as per dwg								

Handwritten: 12-01-06 (2)

Handwritten: 12-01-06

Handwritten: 2

Handwritten: x2

Handwritten: 12/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D3890-041 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Panel, Side
Start Date: 13/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 28/12/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170		0.00							
170									
Small Fab	Memo	0.00							
Small Fab	1- Bond gasket to smooth side of panel as per dwg A/R 3M 1300 adhesive Batch: M119597								

Handwritten signatures and dates:
1. *ES 12/01/10* with circled 2
2. *ES 12/01/10* with circled 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77551

December-13-11 1:40:51 PM

77551

Page 4

Item ID: D3890-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Panel, Side
 Start Date: 13/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 28/12/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	5/12/11/10			(2)			
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>PN 77549</i>	0.00 0.00							<i>12/11/11 (2)</i>
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/11/11 MF 12-01-D</i>

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

December-13-11 1:40:55 PM

Page 1

Work Order ID: 77551

77551

Parent Item: D3890-041

D3890-041

Parent Item Name: Panel, Side

Start Date: 13/12/2011

Required Date: 28/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,890.665	3.618	7.616842			
MI FXS 125-F60029-04									**			B12-1-5	
GE PLASTICS LEXAN SHEET													

D3890-3		Manufactured	No			160	Each	4.0000	2				
D3890-3									**				
Gasket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT018		2890.665							
				115261		234.665							
				119937		2656							
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		4							
				69378		4							

~~119937~~
119937
4

(2)

B12/01/10

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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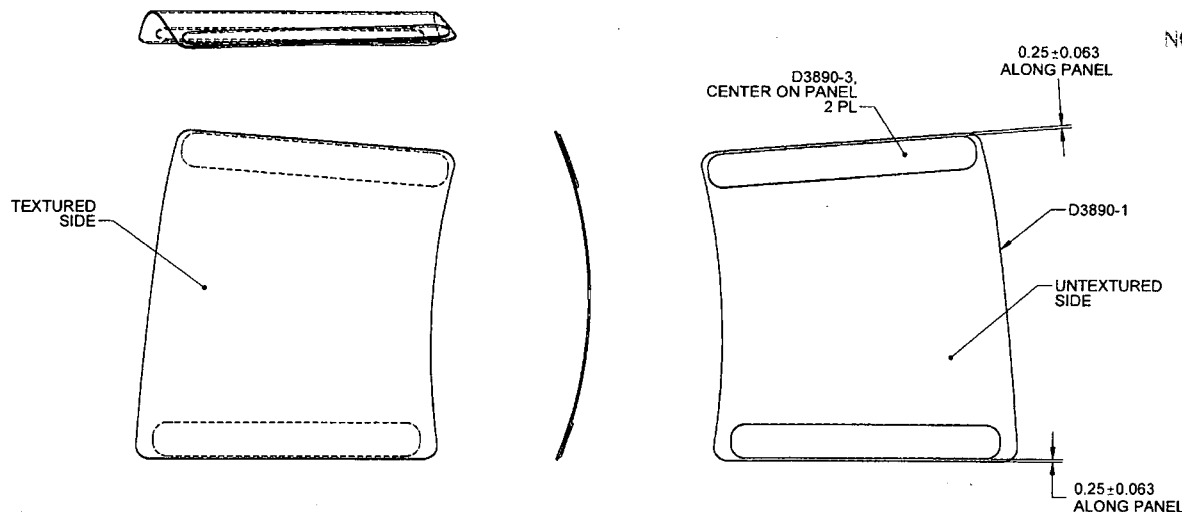
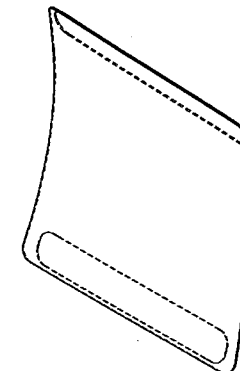
NOTE: Date & initial all entries

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE

STOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 37551 H.L.J
11/12/13



D3890-041 PANEL, SIDE

RELEASED
09/05/13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 1 OF 4
APPROVED	22	TITLE	SCALE
DE APPR.	23	PANEL, SIDE	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

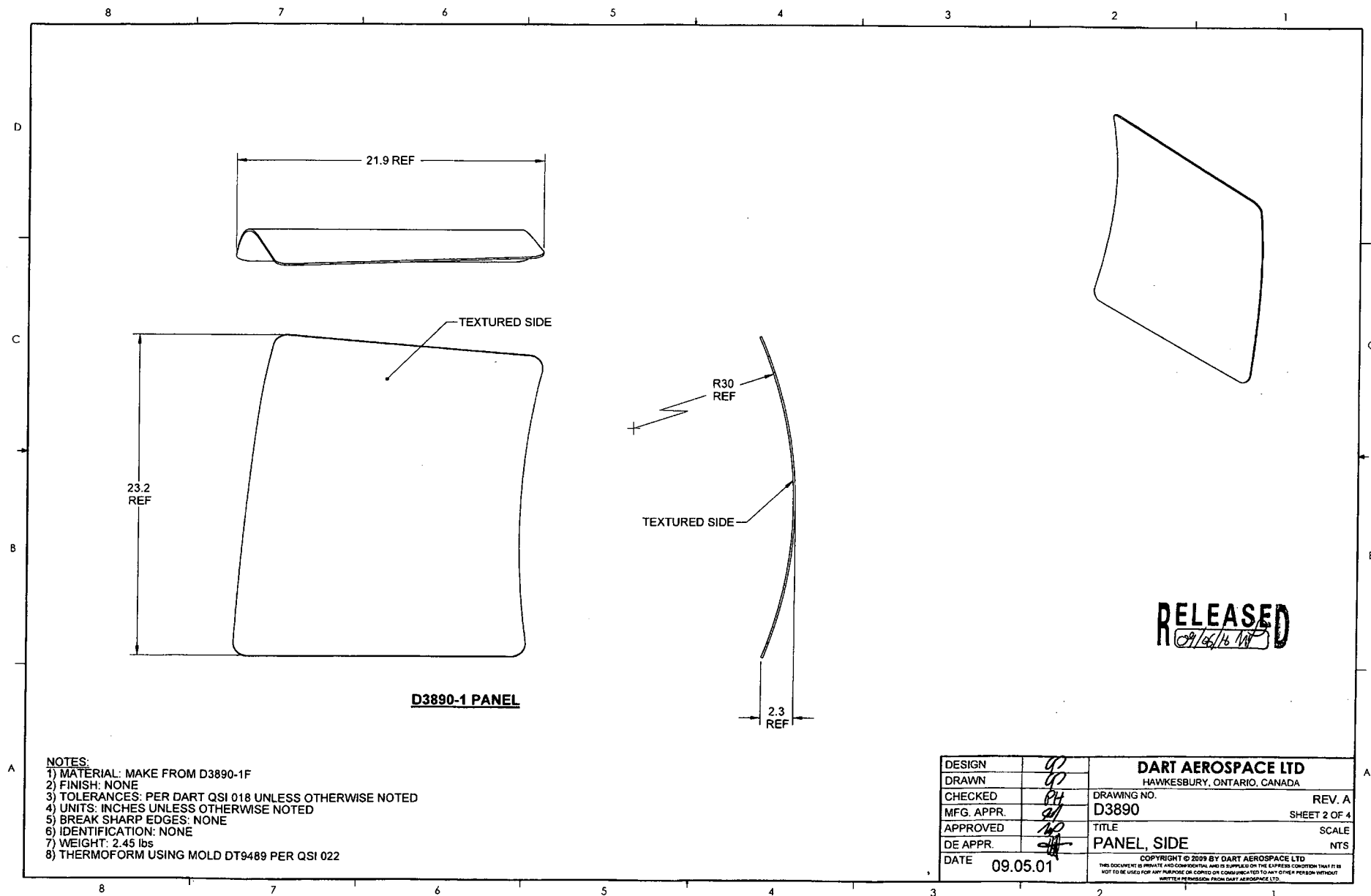
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

77551



W/O:		WORK ORDER CHANGES					
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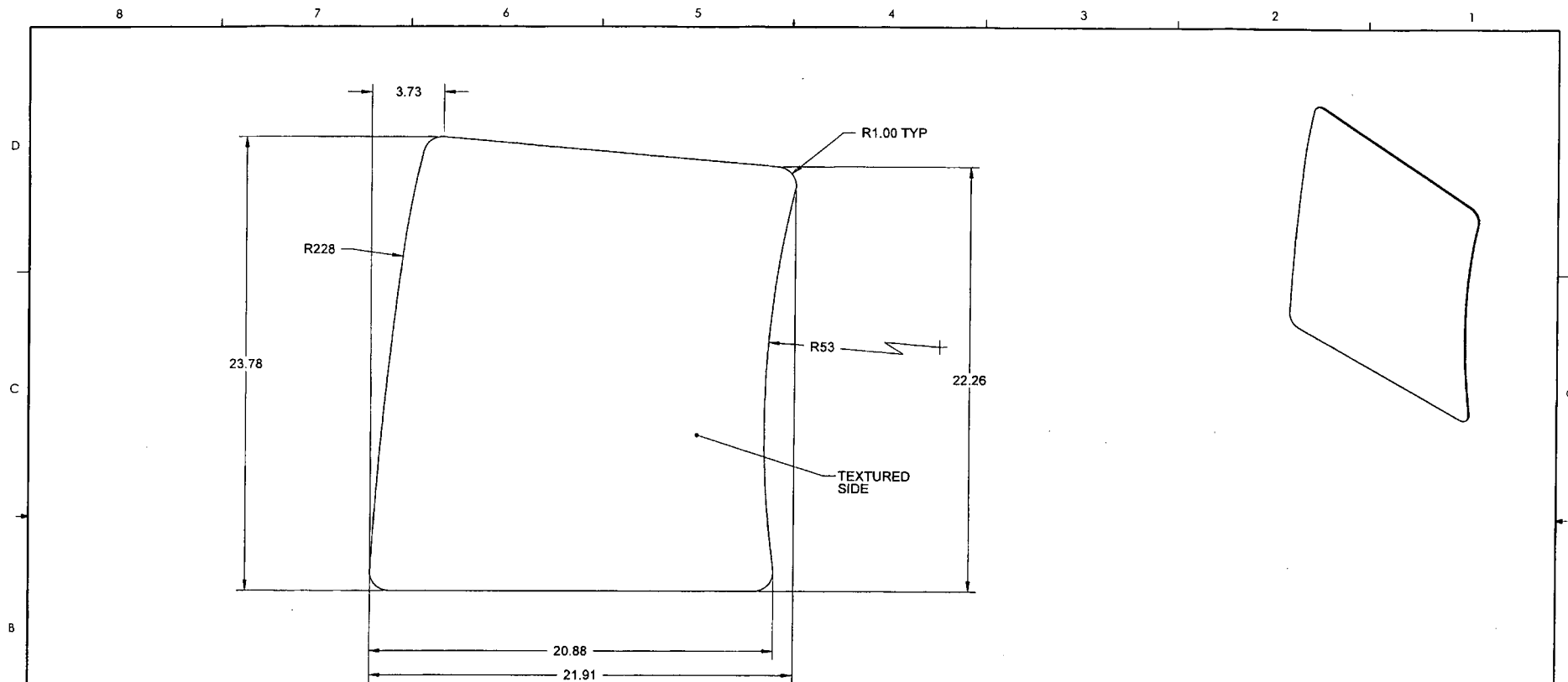
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77551



D3890-1F PANEL

RELEASED
09/06/16

NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

DESIGN	00	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	00			
CHECKED	PH		DRAWING NO.	REV. A
MFG. APPR.	PH		D3890	SHEET 3 OF 4
APPROVED	PH		TITLE	SCALE
DE APPR.	PH		PANEL, SIDE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

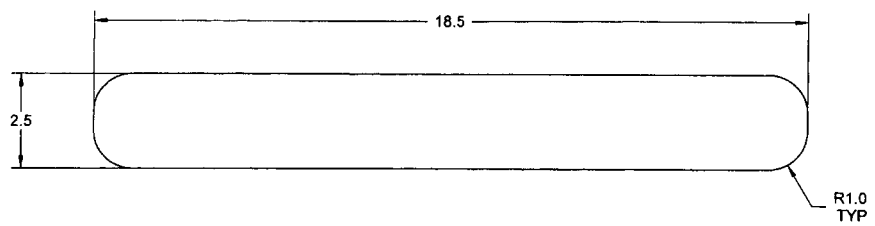
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

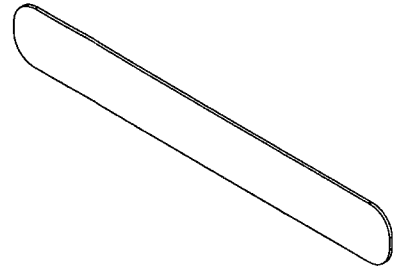
NOTE: Date & initial all entries

77551

0.125
REF



D3890-3 GASKET



RELEASED
21/06/16 MTP

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 4 OF 4
APPROVED	21	TITLE	SCALE
DE APPR.	21	PANEL, SIDE	NTS
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